Work Orde		71		*96	171*					•	Page 1
Revision ID:	D4030-041  Long Basket Ass	sembly (350)		Accept	*N900	040	100	)* s	etup Star Stop	171	S1*
	1/21/13	Start Qty: 1.00 Req'd Qty: 1.00	*1 *1		Cust Item :					"IV	S2*
Approvals:	Process Plan	: \\	Date:	9		Pate:		R	tun Star Stop	1/1	R1* ^\ R2*
Sequence ID/ Work Center II		Operation Description	and time the set of the first transfer or the second secon	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr								1000	
D4030	С	i									
*100 *100* Packaging Packaging	1	Pick Kit <b>Memo</b>		0.00				1			1302-03
*110 * HandFinish		Assemble as per dwg  Memo  ****Mask sand area f	label plate to size of or label, apply label	0.00  0.00  D4086 label, use scotchbrite ****	red pad to lightly			<i>/</i> ×			J3. /02/
*120 *120* QC Quality Control		QC5- Inspect part comp	oleteness to step on V	0.00 0.00 <b>AS</b> 0.00 <b>15</b> 0.00 <b>3</b>	) 6						- <u></u>

NCR: Y	'es	/ No					<b>WORK ORDER NON-C</b>	O	<b>VFORN</b>	ANCE / UP	DATE			•
												QA Closed:	Date:	
Work Orde	r:				-		DISPOSITION				AGAINST D	EPARTMENT/	PROCESS	
Part N	lo.						Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	io.						Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	ript	tion of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator														
/laterial														
etup														
ther														
rocess														·
upplier												]		
raining														
Inapproved														
							F.	AUL	T CATE	GORY				
Landi	ng (	ear					General		_		_	_	_	_
		Bending				[	Bend		Grain		L	Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to (	o/s	[8	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				[8	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.		Γ	E	Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				$\exists$	Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			$\neg$	Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		٦	Cut Too Short	$\Gamma$	Misread	ł	Γ	Power Loss/	Surge	Other
		Ripples in				7	Drill Holes		Offset		_			
		Torque W		xtrusio	n	7	Drawing		Out of (	Calibration				
		Turning S					Finish		Out of S	Sequence				
		Wave/Tw		oe .		_	Folio		Outside	Dimensions		<u> </u>		

Date: \_

DQA:

Work Ord January-23-13				*961	171*							Page
Item ID: Revision ID: Item Name:	D4030-041	t Assembly (350)		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*
Start Date: 1/21/13 Start Qty: 1.00 Required Date: 2/08/13 Req'd Qty: 1.00 Reference:		*1* *1*		Cust Item ID: Customer:								
Approvals:	Process F	Plan:	Date:	Tooling: SPC (Y/N):		ate:		!	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:\_\_

0.00

0.00

0.00

PPP 96139

\*140\*

\*130\*

Packaging Packaging

QC

0.00

Memo Quality Control

MC373-07-08

Page 2

		,	
NCR:	Yes	/	No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Y	es / No				WORK ORDER WORK		VIAITEL / OF L	JA12	QA Closed:	Date	e:
Work Orde	·r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap	- 1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		1									
Material											
Setup											
Other	_										
Process								• -			
Supplier											
Training											
Unapproved						<u> </u>			1		
						AULT CATE	GORY				
Landir r	ng Gear				General ¬	Па .		<u> </u>	٦	Г	7
1	Bending			_	Bend	Grain		<u> </u>	Ovalized	., }	Pressure/Forced
].	Centre No	ot Concer	ntric to (	D/S	BOM/Route	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	<b>—</b>	ion Incomplete	⊢	Part Incorre	- F	Weld
,	Crushed/	Crimped.		<b> </b>	Burrs	<b>—</b>	tions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
-	Cuffs			<u> </u>	Contamination	$\vdash$	enance	-	Part Moved		
ļ	Heat Trea				Countersink	Mislab		<u> </u>	Positioned \		704
	Inspectio		Tube	<u> </u>	Cut Too Short	Misrea	đ	<u>L</u> .	Power Loss,	Surge	Other
	Ripples in			_	Drill Holes	Offset	6 til:				
	Torque W			ı	Drawing	<b>⊢</b>	Calibration				
]	Turning S			-	Finish	<b>—</b>	Secuence				
1	Wave/Tw	ist in Tul	oe e	1	Folio	Outside	e Dimensions				

January-23-13 12:27:47 PM

Work Order ID:

96171

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date: 1/21/13** 

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as per dwg revB DD

10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit o Measu		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	7.0000		1	-		
Placard, Max Load													
				<b>Location</b>		Loc Qty		Loc Code					
				ST093		7							
				8861	11	7			8	8611			
D2530		Manufactured	No			100	Each	13.0000	1	1			
Handle Weldment											179		7,00
				Location		Loc Qty		Loc Code			<b>V</b> >		
				ST255		13							
				9279	99	1							
				9403	30	2			94	1030			
				9447	74	10							
D2535		Manufactured	No			100	Each	81.0000	2	2			
Spring									40 × 20 × 3	****	10	<u>.</u>	***************************************
				<b>Location</b>		Loc Qty		Loc Code			•		
				ST011		81							
				8633	33	31			8	6333			
				925	70	50							
D2537		Manufactured	No			100	Each	114.0000	2	2	v .A	13-	* A - D
Bushing											- J-3	12-	03-0
				Location		Loc Qty		Loc Code					
				ST011		114							
				8550	04	10			8	5504		•	
				8752		40			-				
				927		24							
				947	13	40			•				1
D3913-041		Manufactured	No			100	Each	0.0000	1	1	9480	e /	<i>!</i>
Long Basket Base Assemb	y, 350										1780	1//	()

Date: \_\_\_

NCR: Y	es / No				WORK ORDER NON-O	CONFO	RMANCE /	UPDATE					
	•								QA Closed:	Date:			
Work Orde					DISPOSITION			AGAINST D	EPARTMENT,	PROCESS			
WOIK OIGE					Rework	1	Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	in				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Engineering Quality Other Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
raiti					Use-as-is	l l Th	ermoforming	Finishing		e/Packaging	Other		
NCR N	lo.				Work Order Update	1	Large Fab	Composite		Supplier			
Root				Descri	iption of work order update	Initia	1	Action	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng D	escription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator			1			Ì							
Material							İ						
Setup													
Other									į.		•		
Process													
Supplier							1		ļ		,		
Training									İ				
Unapproved		<u>.</u>				<u> </u>							
					F	AULT CA	TEGORY						
Landir	ng Gear			_	General	<del>1</del>		г			<b>-1</b>		
	Bending			<u> </u>	Bend	Gra		1	Ovalized	-	<b>⊣</b>		
	Centre N	ot Conce	ntric to (	o/s	BOM/Route	<b>├</b> ─	dware	1	Over/Under	<b>├</b>	<b>=</b>		
	Cracks				Broken/Damaged	$\boldsymbol{\vdash}$	ection Incomple		Part Incorre	<u> </u>			
	Crushed/	'Crimped			Burrs		ructior's Incompl	ete/Unclear	Part Lost/M		Wrong Stock Pulled		
	Cuffs				Contamination	<b></b>	intenance		Part Moved				
	Heat Trea	at	1		Countersink	$\vdash$	labeled	]	Positioned		· ¬		
	Inspection	Tube		Cut Too Short	<b></b>	read	Į	Power Loss,	/Surge	Other			
Ripples in Bend Drill Hole					Drill Holes	Offs	et						
	Torque V	Vaves in	Extrusio	n [	Drawing	Out	of Calibration						
	Turning S	Sequence	)		Finish	Out	of Sequence						
	Wave/Tv	vist in Tu	be		Folio	Out	side Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-23-13 12:27:47 PM

Work Order ID:	96171								
Parent Item:	D4030-041							Date: 1/21/13	Required Date: 2/08/13
Parent Item Name:	Long Basket Asse	mbly (350)					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
<b>D3914-041</b> Long Basket Lid Assem	bly (350)	Manufactured	No		100 ZS	Each	9 (1X)	1	15/3/02/00
<b>03917-3</b> Washer		Manufactured	No		100	Each	114.0000	6	1 gs
				Location	Loc Qty		Loc Code		V
				ST072	114				
				92514	53			925	714
				94136	5				
				94137	6				
				94643	50				· · · · · · · · · · · · · · · · · · ·
D3953-3 Gas Spring Stud, Lid		Manufactured	No		100	Each	55.0000	2	2 73
				Location	Loc Qty		Loc Code		•
				GA	1				
				87592	1				
				ST076	54				<del></del>
				88494	14				
				89337	9			993	37
				94744	31				
D3953-7		Manufactured	No		100	Each	67.0000	2	
Spring Spacer		wanatactured							<sup>2</sup> 25
				Location	Loc Qty		Loc Code		•
				ST076	67				
				88393	15			883	793
				89248	12				<del></del>
				94669	40				
D3953-9		Manufactured	No		100	Each	107.0000	2	
Gas Spring Washer		ivianuiaciuleu				234011	107.0000	-	2 75 13-02-0
ous opring washer									
				Location	Loc Qty		Loc Code		
				ST076	107				
				89307	11			79:	<u>30</u> /
				94719	51				
•				95127	45				

										DQA:	Date	:	**************************************
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	1ANCE / UF	PDATE	QA Closed:	Date	•	
Work Ordei	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	o				Rework Scrap Use-as-is Work Order Update		۸ herm	Skid-tube  Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	E	ngineering Quality Other
Root				Descr	iption of work order update	Init	ial	А	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Des	cription	Date	Verification		QC Inspector
Coc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								,					
						FAULT (	CATE	GORY					
Landin	Bending Centre Not Concentric to O/S BoM/Route Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing Turning Sequence Finish Wave/Twist in Tube Folio					Ha In	struct lainte lislabe lisread ffset ut of C ut of S	on Incomplete ions Incomplete nance lecl Calibration sequence	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Tei We Wi	essure/Forced mperature/Cure eld rong Stock Pulled her
	Wave/Tw	ist in Tul	be		Folio		utside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# Picklist Print

January-23-13 12:27:47 PM

Page 3

Work Order ID:	96171											
Parent Item:	D4030-041							Start	Date: 1/21/13		Required Date: 2	2/08/13
Parent Item Name:	Long Basket Assem	bly (350)						Start	t <b>Qty:</b> 1.00		Required Qty: 1	.00
D3953-17 Gas Spring Spacer		Manufactured	No			100	Each	27.0000	2	2	- J.B.	THE RESERVE THE PROPERTY OF TH
				Location	<u>1</u>	Loc Oty		Loc Code				
				ST076	88281	27 11			88	28 i		
					89180	16						
D3953-19 Gas Spring Bracket		Manufactured	No			100	Each	18.0000	1	1	- JB	
				Location	<u>1</u>	Loc Oty		Loc Code			•	
				ST077		18						
					88269 92819	2 16			92.	<del>819</del>		
D3953-21 Gas Spring Bracket		Manufactured	No			100	Each	20.0000	1	1	JB	
				Location	<u>1</u>	Loc Qty		Loc Code			0	
				ST077		20						
					85759 94146	8 12			85	759		
D3969-3 Spring (Basket Lid)		Manufactured	No			100	Each	18.0000		1	73	
				Location	<u>1</u>	Loc Oty		Loc Code			V	
				ST262		18						
					91844	18			_91	744		
AN3-14A Bolt		Purchased	No			100	Each	173.0000	4	4	18	13-02-05
				Location	<u>1</u>	Loc Qty		Loc Code			V	
				ST352		73				、		
					122800	73			123	7 400		
				ST512		100						
					123759	100						

ALC D		,	A1 -
NCR:	Yes	/	No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	LONFORI	VIANCE / UPI	DAIE	QA Closed:	Date	:	
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part N					Rework Scrap	4 I	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	0	•			Use-as-is Work Order Update	] Therm	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	Initial		tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling										÷		
Operator	_						ļ					
Material												
Setup					•					[		
Other Process	_											
Supplier	$\dashv$											
Training	-											
Unapproved	7											
		. <u>.</u>	11		F	AULT CATE	GCIRY					
Landin	ng Gear				General				-	_		
	Bending				Bend	Grain			Ovalized	L	Pressure/Forced	
	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hardwa			Over/Under	<b>⊢</b>	Temperature/Cure	
	Cracks				Broken/Damaged	_	ion Incomplete		Part Incorre	<u> </u>	Weld	
1	Crushed/Crimped. Burrs					<b>—</b>	tions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled	
	Cuffs Contamination					<del></del>	enance	<u> </u>	Part Moved			
	Heat Treat Countersink					Mislab			Positioned \			
Inspection Strip in Tube Cut Too Short						Misrea	đ		Power Loss,	'Surge	Other	
Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing						Offset						
}	<b></b> i `			`  -	Drawing	Out of Calibration Out of Sequence						
	Turning S	-		-	Finish Folio	$\mathbf{H}$	sequence e Dimensions					
i	Wave/Tw	vist in Tu	ne	i	ורטווט	1 Journa	E DITTIGUSIONS				2.00	

## **Picklist Print**

January-23-13 12:27:47 PM

Page 4

Vork Order ID: Parent Item: Parent Item Name:	96171 D4030-041 Long Basket Assembly (350)						Date: 1/21/13		Required Dat	
N3-16A	Purchas	ed No		100	Each	162.0000	2	2	L J B	y: 1.00
•			<b>Location</b>	Loc Qty		Loc Code				
	•		GA	47						
			117441	47						
			ST352	115						
			122407	65			1221	107		
			123900	50			10-	J		
N5-17A olt	Purchas	ed No		100	Each	181.0000	4	4	70	
			Location	Loc Qty		Loc Code			0	
•			GA	36						
			117872	36		•				
			ST337	145			-			
			122416	35			1221	116		
			123831	60						
			124215	50						
N4-12	Purchas	ed No		100	Each	63.0000	3	3	٠	
olt							1123	900	73	
			Location	Loc Qty		Loc Code			·	
			ST356	63						
			122800	63			31722	800		
N310-4	Purchas	ed No	•	100	Each	136.0000	3	3	/	
UT	, ai viidi	· <del></del>							<u></u>	13-02-
			Location	Loc Oty		Loc Code			V	
			ST342	136						
			122800	11						
			123900	25			1239	700		•
			124221	100						

NCD.	Voc	1	Nio
NCR:	Yes	/	No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	PDATE	0461	D	
<del>,,,</del>					<b>,</b> , , , , , , , , , , , , , , , , , ,				QA Closed:	Date	: 
Work Ordei	r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE					Rework	1	Skid-tube	Crosstube		Water Jet	Engineering
Part N	0				Scrap	1 1	Machining Small Fab			d. Eng. Coor.	Quality
, 4, 6, 7, 7				<del></del>	Use-as-is	ł <b>t</b>	moforming	Finishing	ł	e/Packaging	Other
NCR N	0.				Work Order Update	1	Large Fab	Composite		Supplier	]
Root					ption of work order update	Initial	1	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material	_										
Setup	4										
Other											
Process	_										
Supplier	_										
Training Unapproved	-										
Unapproved		i	L		F	AULT CAT	FGORY			1	
Landin	g Gear				General	, , , , , , , , , , , , , , , , , , , ,					
Γ	Bending			Г	Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
ŀ	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruc	ctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Trea	et			Countersink	Mislab	eled		Positioned \	Wrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	ad		Power Loss,	'Surge	Other
	Ripples ir	n Bend			Drill Holes	Offset					
	Torque V	Vaves in E	Extrusion	n [	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of	Sequence				
ſ	Wave/Tw	vist in Tul	be		Folio	Outsic	le Dimensions				

Picklist Print
January-23-13 12:27:47 PM

Page 5

Work Order ID:	96171				······································					——————————————————————————————————————	
Parent Item:	D4030-041						Start D	ate: 1/21/13		Required Date:	2/08/13
Parent Item Name:	Long Basket Assembly (350)	)					Start (	Qty: 1.00		Required Qty:	1.00
<b>AN310C4</b> Nut	Purch	ased No			100	Each	130.0000	2	2	18	
			Locatio	<u>n</u>	Loc Oty		Loc Code			V	
			ST342		130						
				123831	30			1239	83/		
				124221	100						
<b>MS21042L3</b> Nut	Purch	ased No			100	Each	7,697.0000	6	6	-78	
			Locatio	<u>n</u>	Loc Qty		Loc Code			U	
			FP001		3						
				122141	3			· · · · · · · · · · · · · · · · · · ·			
			GA		434						
				122452	434						
			ST314		268						
				117885	32						
				119017	55						
				119075	138			-			
				123265	43						
			ST506		6992			: - 16	(4.7)		
				123900	2992			1239	00		
MS21042L5				124291	4000						
Nut	Purch	ased No			100	Each	1,302.0000	4	4	73	13-02-0
			Locatio	<u>on</u>	Loc Qty		Loc Code				
•			ST314		602						
				108827	4						
				116548	43						
				119109	20						
				121652 122452	12 511						
				2937	12			122	452		
			ST506		700			<u>,, , , , , , , , , , , , , , , , , , ,</u>			
			\$1300	123900	700						
				-40,00							

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	-CON	IFORN	MANCE / UP	PDATE	QA Closed:	Date:	
Work Orde	r:				DISPOSITION			1	AGAINST DE	PARTMENT	/PROCESS	
	0				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	nining Small Fab Prod. Eng. Coor. Coming Finishing Rec/Store/Packaging			Engineering Quality Other
Root				Descri	tion of work order update	<b>i</b>	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
ooc/Data quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						FAUL	T CATE	GCIRY				
Landir	g Gear Bending				General Bend		Grain		Γ	Ovalized		Pressure/Forced
	Centre N Cracks Crushed/			o/s	BOM/Route Broken/Damaged Burrs			re on Incomplete ions Incomplete	/Unclear	Over/Under Part Incorre Part Lost/M	ct	Temperature/Cure Weld Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	<u> </u>	_
-	Heat Trea			_	Countersink		Mislabe		<b></b>	Positioned \	_	٦٥,,,,
}	Inspection Ripples in	•	Tube	-	Cut Too Short Drill Holes		Misread Offset	1		Power Loss,	Surge	Other
}	Torque V		Extrusion	,	Drawing		l	Calibration				
ł	Turning				Finish	<u> </u>	4	Sequence				
Ì	Wave/Tv				Folio			Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-23-13 12:27:48 PM

Work Order ID: Parent Item: Parent Item Name:	96171 D4030-041 Long Basket Asse	embly (350)						Date: 1/21/13  Qty: 1.00		Required Date:	
<b>MS24665-151</b> Cotter Pin		Purchased	No		100	Each	171.0000	3	3		
				<b>Location</b>	Loc Qty		Loc Code			•	
				GA	43						
				17566	43						
				ST323	128				<del>-</del>	_	
				122802	128			1220	102		
MS24665-300 Cotter Pin		Purchased	No		100	Each	47.0000	2	2	JB	
				Location	Loc Oty		Loc Code			v	
				GA	42						
				118234	42						
				ST299	5						
				118234	5				234		
NAS1149F0432P Washer		Purchased	No		100	Each	854.0000	6	6		.44964-3
				Location	Loc Oty		Loc Code			·	
				ST295	854						
				122151	2						
				123522	52				a . a		
				123900	800			123	700		
NAS1149F0563P Washer		Purchased	No		100	Each	790.0000	4	4	900	13-02-03
				Location	Loc Qty		Loc Code				
				ST295	790						
				121350	790			1213	20	•	

NCR:	Yes	1	No

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR: Y	es / No				WORK ORDER NON-O	CONFO	RM.	ANCE / UP	DATE			
	,							•		QA Closed:	Date	e:
Work Orde	r·				DISPOSITION			-	AGAINST DI	EPARTMENT	/PROCESS	
Work Orac			<del></del> -		Rework	1	SI	kid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1	Machining Small Fab Prod. Eng. Co			d. Eng. Coor.	Quality	
					Use-as-is	The	ermo	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0.				Work Order Update	]	Large Fab Composite Supplier					
Root				Descri	ption of work order update	Initial		Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						ļ						
quip/Tooling	_										·	
Operator						1						
Material												
Setup	_											
Other		•	]				- 1					
Process												
Supplier										ļ		
Training												
Unapproved												
					F	<b>AULT CA</b>	TEG	CIRY				
Landin	ng Gear				General				_			
	Bending				Bend	Grai	n			Ovalized	<u> </u>	Pressure/Forced
<u> </u>	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hard	lware	9	_	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ectio	n Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instr	uctio	oris Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	nten	ance		Part Moved		
	Heat Trea	at			Countersink	Misla	abele	ed	L	Positioned \	<b>N</b> rong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead			Power Loss,	/Surge	Other
	Ripples ir	n Bend			Drill Holes	Offse	et					
Ţ	Torque V	Vaves in I	Extrusion	n	Drawing	Out	of Ca	libration				
Ī	Turning S	Sequence	!	Γ	Finish	Out	of Se	quence				
Ì	Wave/Tw	vist in Tul	be		Folio	Outs	side D	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

Page 7

Work Order ID:	96171										
Parent Item:	D4030-041						Start D	ate: 1/21/13		Required Date	: 2/08/13
Parent Item Name:	Long Basket Assembly (350)	)					Start C	<b>Qty:</b> 1.00		Required Qty	
NAS1149F0332P WASHER	Purch	ased No			100	Each	10,676.000	8	8	73	
			Location		Loc Oty		Loc Code			0	
			GA		202						
				122063	202			-			
			ST294		400						
				122063	400			1220	263		
			ST295		74						
				123352	74						
			st510		10000						
				123900	10000						
NAS1149C0432R Washer	Purch	ased No			100	Each	3,086.0000	2	2	73	<u> 13-02-0</u> 5
			Location		Loc Qty		Loc Code				
			GA		65						
				121255	65						
			ST292		3021			-			

21

3000

122441

119124

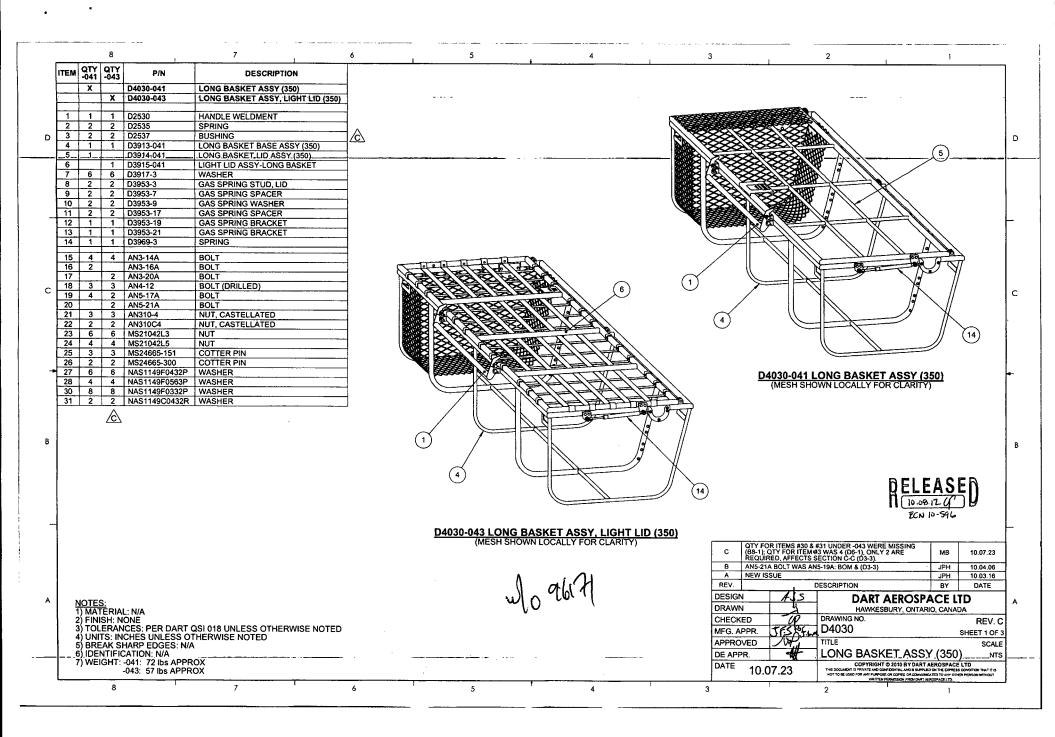
122441

NCR:	Yes	1	No
NCK:	res	/	INO

DQA: \_\_\_\_\_ Date: \_\_\_\_

Part No.    Scrap   Use-as-is   Use-as-as-is   Use-as-as-is   Use-as-as-as-as-as-as-as-as-as-as-as-as-as-	
Rework Skid-tube Crosstube Prod. Eng. Coor. Use-as-is Use-as-is Large Fab Composite Step Qty Or Non-conformance Chief Eng Description Date Verification Composite Step Qty Other Cross Composite Step Qty Other Cross Composite Skid-tube Crosstube Matchining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier Supplier Composite Supplier Supplier Composite Step Qty Or Non-conformance Chief Eng Description Date Verification Composite Step Qty Other Cross Composite Skid-tube Crosstube Matchining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Composite Supplier Composite Supplier Composite Supplier Composite Step Qty Other Cross Composite Shape Composite Step Qty Other Cross Composite Shape Co	
NCR No.    Use-as-is   Work Order Update   Large Fab   Composite   Supplier	ineering Quality
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification Coc/Data Equip/Tooling Operator Material Setup Other Process	Other
Doc/Data Equip/Tooling Operator Material Setup Other Process	
Equip/Tooling Operator Omega of the control of the	C Inspector
Operator  Material  Setup Other  Process	
Material Setup Other Process	
Setup Other Process	
Other Process	
Process	
Supplier	
Training	
Unapproved	
FAULT CATEGORY	
Landing Gear General  Bending Bend Grain Ovalized Press	sure/Forced
	perature/Cure
Harden Ha	ng Stock Pulled
Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wro	ig Stock i uncu
Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other	ır
Ripples in Bend Drill Holes Offset	
Torque Waves in Extrusion Drawing Out of Calibration	
Turning Sequence Finish Out of Sequence	
Wave/Twist in Tube Folio Outside Dimensions	

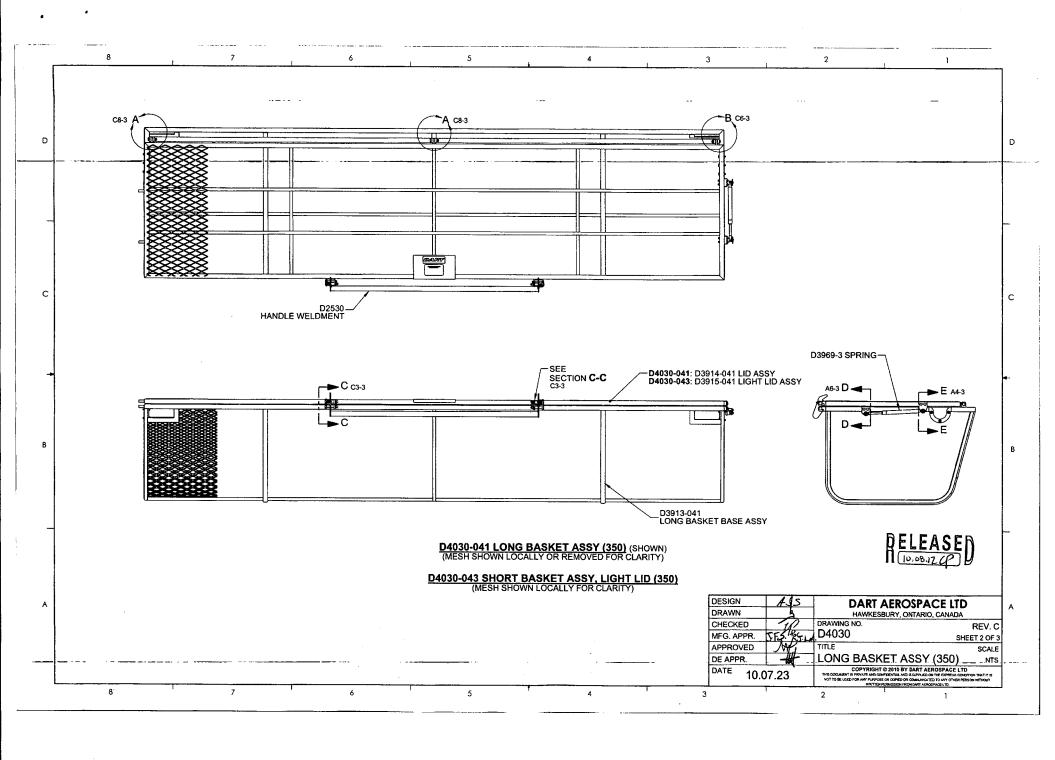
Wave/Twist in Tube



NCR:	Yes	1	No
NUN.	162	/	INO

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR: Y	es / No				WORK ORDER NON-	CONFORI	MANCE / UP	DATE	QA Closed:	Date	:		
18/ m.ml. Ox-1-		14.4183 - 119. 20			DISPOSITION		AGAINST			DEPARTMENT/PROCESS			
Work Orde					Rework	]	Skid-tube Crosstube		Duo	Water Jet	Engineering Quality		
Part N	0				Scrap Use-as-is	-1 1	Machining Small Fab Thermoforming Finishing		Prod. Eng. Coor. Rec/Store/Packaging		Other		
NCR No.					Work Order Update	d linen	Large Fab Composite		Supplier				
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data													
quip/Tooling										÷			
Operator													
Material		1											
Setup													
Other								•					
Process	_	j	'										
Supplier													
Training	_												
Unapproved		<u> </u>	l			AULT CATE	L CORV		<u> </u>	<u> </u>			
						AULI CATE	GURT						
Landin	ng Gear			<u></u>	General Bend	Grain			Ovalized	Г	Pressure/Forced		
	Bending	- <b>+</b> C	_+=:_ + _ (	~,	BOM/Route	<b>⊢</b> ⊣	aro.	<del> </del>	Over/Under tolerance		Temperature/Cure		
}	Centre Not Concentric to O/S				Broken/Damaged	$\vdash$	Hardware Inspection Incomplete		Part Incorrect		Weld		
ŀ	Crushed/Crimped				Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled		
ŀ	Crushed/Crimped.				Contamination	Maintenance		- Officieal	Part Moved				
}	Heat Trea	at		<u> </u>	Countersink	<b>⊢</b>	Mislabeled		Positioned \	Vrong			
ļ	<del>-</del>				Cut Too Short	<del>     </del>	Misread		Power Loss/Surge		Other		
ŀ	Inspection Strip in Tube Ripples in Bend				Drill Holes	Offset	<b>⊣</b>		7. 24.6. 5333/		1		
}	Torque W		Extrusion	,	Drawing	$\vdash$	Calibration						
ł	<b></b>			`	Finish	<del></del>	Sequence						
<u></u>	Turning Sequence Wave/Twist in Tube				Folio	<b>├</b>	e Dimensions						



DQA: Date:

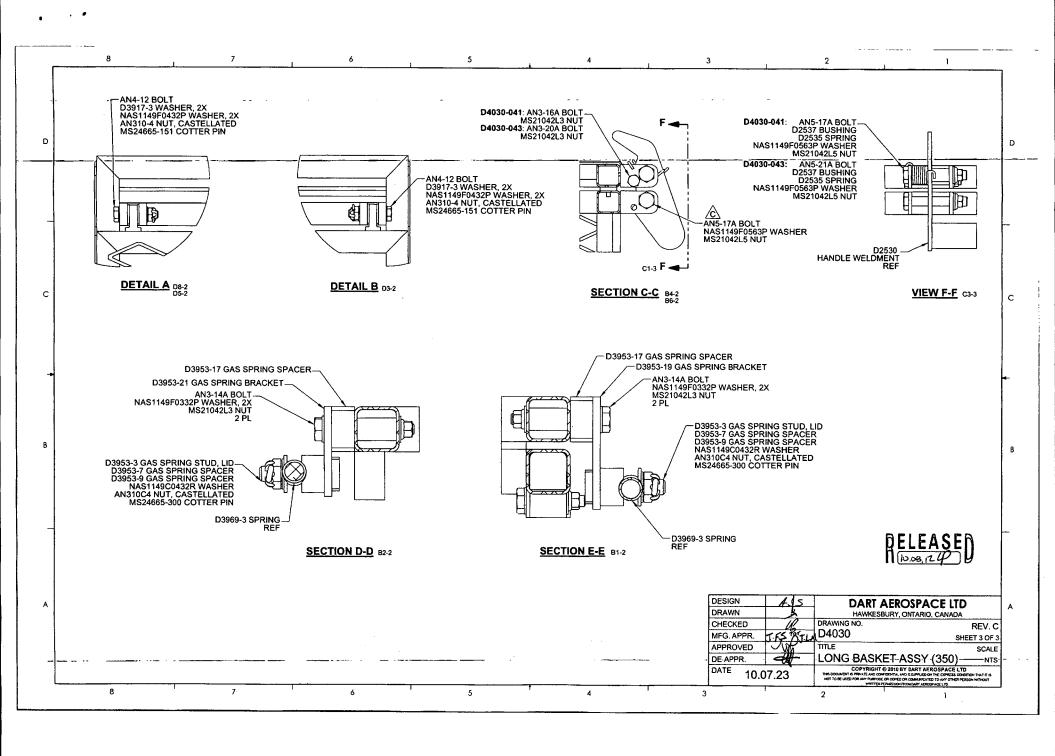
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
									QA Closed:	Date	:	
Work Orde	r:				DISPOSITION AGAINST (			AGAINST DE	DEPARTMENT/PROCESS			
Part N	o				Rework Scrap	<b>→ !</b>	Skid-tube Crosstube  Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality Qubes	
NCR No.					Use-as-is Work Order Update	Inerr	moforming Large Fab	Finishing Composite				
Root				Descri	ption of work order update	Initial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data												
quip/Tooling										·		
Operator							ļ					
Material		1				1						
Setup		ł							1			
Other												
Process	_	İ	·									
Supplier		i										
Training												
Unapproved							<u> </u>		<u></u>			
						FAULT CATE	EGCIRY					
Landir	ng Gear			_	General	_		<del></del>	<b>-</b>	_		
	Bending	Bending			Bend	Grain			Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S			o/s	BOM/Route	<b></b>	Hardware		Over/Under tolerance		Temperature/Cure	
	Cracks				Broken/Damaged	_	Inspection Incomplete		Part Incorrect		Weld	
]	Crushed/Crimped				Burrs	<b>—</b>	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
	Cuffs				Contamination	<b>—</b>	Maintenance		Part Moved			
	Heat Treat				Countersink	$\vdash$	Mislabeled		Positioned Wrong		<del></del> -	
Į	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	Misread		Power Loss/	'Surge	Other	
	Ripples in	n Bend			Drill Holes	Offset						
Į	Torque W	Vaves in E	Extrusio	n L	Drawing	<del></del>	Calibration					
1	Turning Sequence				Finish	Out of	Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



NICD.	Voc	1	Nio
NCR:	Yes	/	No

Date:

NCR: Y	es / No				WORK ORDER NON-C	LUNFUR	IVIAINCE / UP	DATE	QA Closed:	Date	:	
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	0			<del> </del>	Rework Scrap	]   	Skid-tube Machining	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor.	Engineering Quality Other	
NCR No.					Use-as-is Work Order Update	]   Inei	Thermoforming Finishing Large Fab Composite					
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling	_		}									
Operator	_										!	
Material	_											
Setup							,					
Other	_											
Process												
Supplier Training												
Uñapproved												
1		<u> </u>	<u> </u>		F	AULT CAT	EGCIRY		<u> </u>			
Landir	ng Gear				General							
	Bending				Bend	Grain	Grain		Ovalized		Pressure/Forced	
	Centre N	ot Conce	ntric to (	o/s	BOM/Route	Hardy	Hardware		Over/Under tolerance		Temperature/Cure	
	Cracks				Broken/Damaged	Inspe	Inspection Incomplete		Part Incorrect		Weld	
	Crushed/	Crimped.			Burrs	Instru	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
	Cuffs				Contamination	Main	Maintenance		Part Moved			
	Heat Trea	at			Countersink	Misla	Mislabeled		Positioned \			
. [	Inspection Strip in Tube				Cut Too Short	$\vdash$	Misread		Power Loss,	'Surge	Other	
[	Ripples in	n Bend			Drill Holes	<b></b>	Offset					
	Torque V	Vaves in I	Extrusio	n L	Drawing	<del></del>	f Calibration					
	Turning S	Sequence	<u> </u>	_	Finish	Out o	f Sequence			<del></del>		
	Wave/Twist in Tube				Folio	Outsi	de Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G